

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028811**Date Inspected:** 27-Nov-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Welder Rick Chouinard #8959:

Welder was observed performing R1 exterior weld repairs on weld 12W W2.1-C1 indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors between Y 30,000 and 31,000. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1000 Repair for Shielded Metal Arc Welding (SMAW). Welder was observed preheating the weld prior to welding. Welding parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above. Weld sections at Y 18,600 to 31,000 is non SPCM, a "Request for Weld Repair" or (RWR) is not required for R1 repairs.

Welder Wai Kit Lai #2953:

Welder was observed performing R1 exterior weld repairs on weld 12W W2.1-C1 indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors between Y 25,800 and 26,800. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1000 Repair for Shielded Metal Arc Welding (SMAW). Welder was observed preheating the weld prior to welding. Welding parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above. Weld sections at Y 18,600 to 31,000 is non SPCM, a "Request for Weld Repair" or (RWR) is not required for R1 repairs.

Welders Deli Zhang #4735 and Lin E Yun #9344:

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Welders were observed welding Drip Edge Plates at Panel Point 111 to the “C” side plate. Welders were observed utilizing Welding Procedure Specifications (WPS) ABF-WPS-D15-1030 Rev.1 for the splice butt weld between Drip Edge Plates and (WPS) ABF-WPS-D15-F1200A Rev.2 for attachment welds to the “C” side plate. Welders were observed preheating the welds prior to welding. Welding parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above.

Welders Guo Wu Chen #1556 and Jin Quan Huang #9340:

Welders were observed welding Drip Edge Plates at Panel Point 118 to the “C” side plate. Welders were observed utilizing Welding Procedure Specifications (WPS) ABF-WPS-D15-1030 Rev.1 for the splice butt weld between Drip Edge Plates and (WPS) ABF-WPS-D15-F1200A Rev.2 for attachment welds to the “C” side plate. Welders were observed preheating the welds prior to welding. Welding parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above.

Non-Destructive Testing (NDT)

This QA performed Visual (VT) and Magnetic Particle Testing (MPT) on the following:
Weld 13E PP120 E2.0-FBW1, (MPT Accept, 850mm)

This QA Inspector completed the report form TL-6028 on this date noting items acceptance or rejection as per applicable code. The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

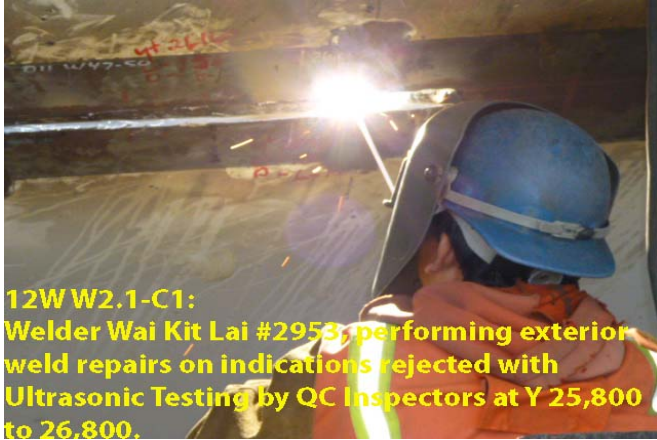
This QA also performed a joint Ultrasonic Testing Shear Wave with QC Inspector John Pagliero on weld 14E PP128 BPB-S in way of the bike path beam. This QA confirms the findings by the QC Inspector. Rejects were noted in the weld at Y locations 130, 190, 300, 400, 410 and 510. A TL-6027 report was not required from this QA Inspector as per QA Lead Danny Reyes. See the UT report by QC Inspector for detailed information pertaining to this inspection.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

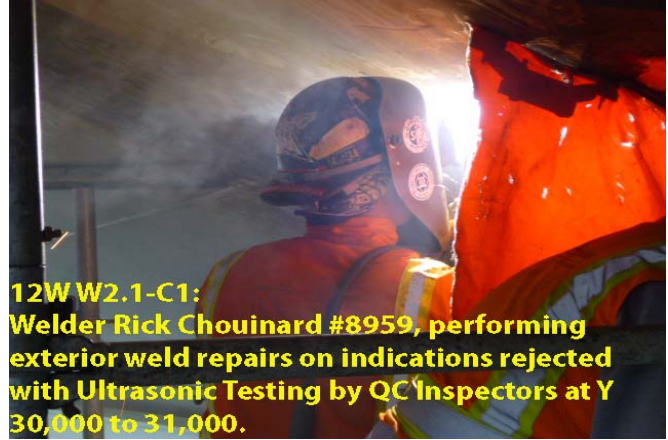


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12W W2.1-C1:
Welder Wai Kit Lai #2953, performing exterior
weld repairs on indications rejected with
Ultrasonic Testing by QC Inspectors at Y 25,800
to 26,800.



12W W2.1-C1:
Welder Rick Chouinard #8959, performing
exterior weld repairs on indications rejected
with Ultrasonic Testing by QC Inspectors at Y
30,000 to 31,000.

Summary of Conversations:

Conversations this day as required for scope of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
